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D3793-3

Job Sheet 200630



Part No: D3793-3

Job Qty: 10 pcs

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/13/19

Job Tracking No:

Due Date: 10/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3793 REV.B IPP Rev:A 08-05-13 new issue DD verified by:EC IPP Rev:B 08-05-23 revA as per dwg
DD verified by:EC IPP REV:C 18.11.09 AS PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		10/14/19	0.17	1.31	Waterjet - Flow		02/19/10/02
110	QC 2	10 pcs		10/14/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		02/19/10/02
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

120 QC 8	10 pcs	10/14/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	OCT 02 2019 DAS
				QC 8 - 52	40
				QC 8 - 23	9-89
				QC 8 - 57	
				QC 8 - 76	
130 Small Fab - Brake NC - B4B	10 pcs	10/14/19	0.25 0.32	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	OCT 03 2019
140 QC 5	10 pcs	10/14/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	DAS
				QC 5 - 81	61
					9-89
150 Spray Paint - 2 - B4B	10 pcs	10/14/19	0.00 1.00	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	

160	QC 3	10 pcs	10/14/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
170	Packaging 3-1 - Stock - B4B	10 pcs	10/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	FP-002 XL 19-10-7
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	

180 QC 21 - SA	10 pcs	10/14/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op **100** - 1-Cut as per Dwg D3793 Dwg Rev: B Prog Rev: B 2-Debur if necessary

Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - (Form as per dwg) 1-Debur if necessary 2-Form on Brake as per Dwg D3793 using Jigs
140 - (QC5- Inspect part completeness to step on W/O)
150 - APPLY TEXTURED COATING ON CONCAVE SURFACE AS PER DWG AND QSI
 BATCH: 5217452
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	12.8280 sf (1.2828 ea)	100-Waterjet - Flow - 1	<u>S200296</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S20GA	13	126	0

Part Specifications

Specifications could not be found.

Plex 9/13/19 10:58 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 200630
Description: Wearshoe		Part Number: D3793-3
Inspection Dwg: D3793	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.187	1		V=0.02	
0.300	+/-0.010	0.299	1		Tap	
1.89	+/-0.010	1.89	1			
4.389	+/-0.010	4.388	1			
6.55	+/-0.010	6.55	1			
6.00	+/-0.030	6.00	1			
6.75	+/-0.030	6.75	1			
2.000	+/-0.010	2.003	1			
4.750	+/-0.010	4.751	1			
9.500	+/-0.010	9.499	1			
14.250	+/-0.010	14.250	1			
17.750	+/-0.010	17.750	1			
26.735	+/-0.010	26.735	1			
Ø0.531 x 0.780	+0.008/-0.001	0.530 x 0.781	1			
0.330	+/-0.010	0.332	1			

Measured by: <i>AS</i>	Audited by: DAS 40	Prototype Approval:	N/A
Date: 19/10/01	Date: OCT 9 2019	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	
B	19.01.22	Revision and dimension changes.	MG <i>[Signature]</i>	<i>[Signature]</i>



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework Scrap Use-as-is	Cross tube Small Fab Finishing	Skid-tube Machining Large Fab	Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	Engineering Water Jet Supplier Quality
Part No. _____					
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
		MRB (Q51042)			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:			
		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up			
		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			